Date:

Wednesday, 18/06/2008 1;26:39 PM

User:

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 39920 **Estimate Number**

: 10245

P.O. Number

Julie Lecoca

This Issue

: 18/06/2008

: NC

: 11 : 39505

S.O. No. :

: SMALL /MED FAB

Type

Part Number **Drawing Number**

Material

Due Date

Drawing Name

: D2010101

: D2010 PRELIM

: MIRROR BRACKET

Project Number : N/A

Drawing Revision

: PRELIM

: 30/06/2008

Qty:

20 Um:

Each

Written By

Prsht Rev.

First Issue

Checked & Approved By Comment

Previous Run

Added Rev. C1 KJ/RF

07-08-015 Now on WaterJet Est Rev:F

Verified By:EC as per ECN1195P DD verified by:EC Est Rev:G 08-05-27

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M2024T3S063

2024-T3 .063 sheet

Comment: Qty.: 0.3646 sf(s)/Unit Total:

7.2912 sf(s)

108415

Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)

Batch: 1

H3

2.0

WATER JET

Comment: FLOW WATER JET



1-Cut as per Dwg D2010-101

Prog Rev:_

B 8-7-3



2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF MACHINE

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1

5.0

SMALL FAB 1

Comment: SMALL & MEDIUM FAB RESOURCE

Deburr

courter

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
· · · · · · · · · · · · · · · ·		.,							
		•							

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
			QA: N/C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE					(NCR)	()			
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C			
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		A 60							

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:26:39 PM User: Julie Lecoca **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: MIRROR BRACKET** Job Number: 39920 Part Number: D2010101 Job Number: Seq. #: **Machine Or Operation:** Description: BRAKE NC NC BRAKE 6.0 Comment: NC BRAKE Form as per Dwg D2010 FE032EF Inserts 10.0 Comment: Qty.: 80.0000 Each(s) 4.0000 Each(s)/Unit Total: Inserts Pick: Qty Part Number Description FE-032-EF Insert SMALL FAB 120 Comment: SMALL & MEDIUM FAB RESOURCE 1 Install fasteners per Dwg D2010 QC5 13.0 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING 60 m102316 Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: QC3 COAT/CHEMICAL CONVE Comment: INSPECT POWDER COAT PACKAGING ' PACKAGING RESOURCE #1 14.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval Ochrispector			
. \&	6.1	Inspect ac #5	9	08/07/07	Ét)	4	08/09/			
solst la	70	chemical coat AS Per OSZ005.	1BR	08-07-08	2	. &	Sodole			
		CA								

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
			QA: N/C Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification		Γ		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Action Description Sign &		Approval Chief Eng	Approval QC Inspector		

NOTE: Date & initial all entries

Date:

Wednesday, 18/06/2008 1:26:39 PM

User: ,

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 39920

Part Number: D2010101

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/149

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:			WORK ORDE	R CHANGES								
DATE	STEP	PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		Ť										
Part No	:	PAR #:	Fault Category:	NO	R: Yes	No DQ	A:	_ Date: _				

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B			Verification Approva	Anneced				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	cription Sign & Date		Approval Chief Eng	Approval QC Inspector			
		4.	771-214								

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39920
Description: Bracket	Part Number:	D2010-101
Inspection Dwg: D2010 Rev: C2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension			Inspection	
6.56	+/-0.030	6.568	¥			
5.81	+/-0.030	5,806	*			
0.38	+/-0.030	<i>:3</i> 6	*			
0.75	+/-0.030	,75	>			
0.38	+/-0.030	-38	×			
5.06	+/-0.030	NIA				
1.375	+/-0.010	1.374	ير			
Ø0.290	+0.005 -0.000	,291	×			
7.060	+/-0.010	7.657	X			
Ø0.201	+0.005 -0.000	Eof.	¥			
6.30	+/-0.030	6.302	×		1	
			4.70			
						()
:		4,				
		-				

Measured by: \3	Audited by:	Pro	ototype Approval:	N/A
Date: 8-7-3	Date: 08/07/3		Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.10.06	New Issue	KJ/RF	01
В	06.03.08	Dwg rev. changed	KJ/JLM ox	





